

CLAIMS:

1. A threaded joint for an oil well pipe in which an axial-direction residual stress of a threaded bottom part is -400 MPa or less as a value in X-ray stress analysis between a surface and a part with a depth of 40 μm .
2. A method for manufacturing a threaded joint for an oil well pipe, comprising a step of injecting and spraying particles having hardness of HRC50 or more and a particle diameter of 30 to 300 μm to a surface of a material to be treated at air pressure of 0.3 to 0.5 MPa.
3. The method for manufacturing the threaded joint for an oil well pipe according to claim 2, wherein a thread shape of the threaded joint for an oil well pipe is any one of an API buttress thread and a round thread.
4. The method for manufacturing the threaded joint for an oil well pipe according to claim 2 or 3, wherein the particle diameter is 50 to 100 μm .
5. The method for manufacturing the threaded joint for an oil well pipe according to any one of claims 2 to 4, wherein the injecting and spraying treatment is performed to only an incomplete threaded portion.
6. The method for manufacturing the threaded joint for an oil well pipe according to any one of claims 2 to 5, wherein the injecting and spraying treatment is executed at 3 sec/cm^2 or less.